

*SPUT*

Date: Monday, 6/12/2006 3:25:36 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 27488 -2  
Estimate Number : 10519  
P.O. Number : N/A  
This Issue : 6/12/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : PURCHASED PARTS  
Previous Run : 26351

Drawing Name : CAP  
Part Number : D2855  
Drawing Number : D2855 REV. A  
Project Number : N/A  
Drawing Revision : A  
Material : N/A  
Due Date : 6/30/2006

*6*

Qty: 25 Um: Each

Written By : *[Signature]*  
Checked & Approved By : *[Signature]* 06-06-13  
Comment : Est: B 00.06/22 Added receiving step & removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING  
Issue P/O: 1490 *C 206115/04 (25) 100*  
Cast per Dwg D2855  
Material Release Note Required

2.0	D2855P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)  
CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Recieve & Inspect for Transit Damage  
Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Drill as per Dwg D2855 using DT8235  
2- Open holes to 19/64"  
3- Deburr

*SP 06/06/23 90*

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 27488

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*Job 08-23*

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*Green*

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*A.M. 06-10-02*

*(6)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FC 06 10 02 (6)*

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 50.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

*m19393*

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

*FC 06 10 02*

*(12)*

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

*FC 06 10 02*

*(6)*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*MA 06 10 02*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

*MA*

*Level 2 inspection*

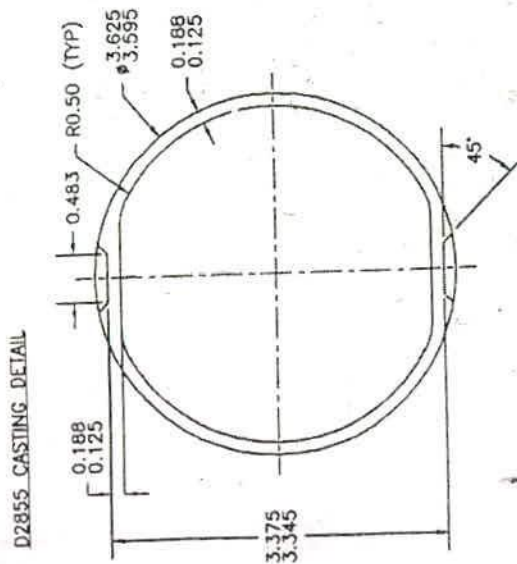
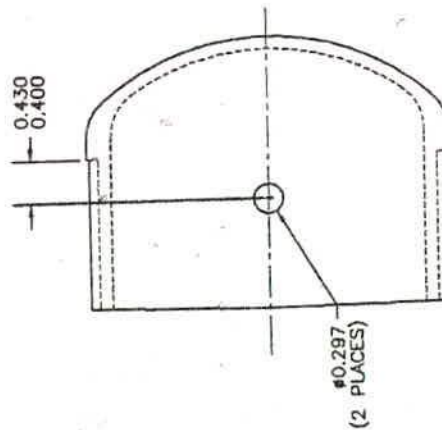
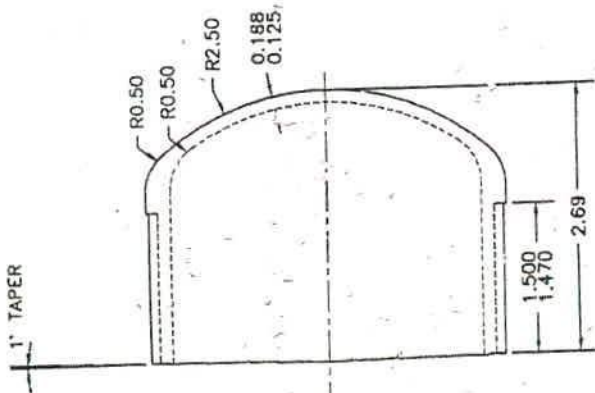
*06/10/03  
H 06-12-03*



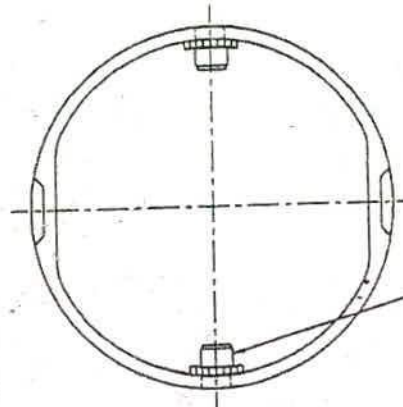


DESIGN <i>JA</i>	DRAWN BY <i>JA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2855	REV. A SHEET 1 OF 1
DATE 98.12.12		TITLE CAP	SCALE NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	

RELEASED  
98.12.14 DS



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART OSI 005  
TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED  
MATERIAL: CAST ALUMINIUM ALLOY AJ356.2 (F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27488

CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-716 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 831-1331 FAX: (514) 831-8448Expédié à  
Shipped

DART AEROSPACE

1270 Aberdeen Street

Hawksbury, ON, K6A 1K7

A.F. &amp; P.W. Série no./Serial no.

Packing

Date: 14/08/2006 Slip No. 6111

Vôtre No. Commande 1490

Your order No.

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
100	DRWG D 2855 rev A	Z098046	A356.2	B#0619301 Ingot #815076

Analyses  
Analysis (as in Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.44%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne  
Yield :Résistance à la tension :  
Tensile Strength :Allongement par pouce carré :  
P.S.I. Elongation :

%

Pour et au nom de  
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :  
Par/Per :

Coc-100